

Work Order ID 66559

Tuesday, February 22, 2011 9:56:34 AM

Page 1

Item ID: D3536-15

Accept

Revision ID:

Item Name: Gasket

Start Date: 2/23/2011 Start Qty: 20.00

Required Date: 3/4/2011 Req'd Qty: 20.00

Reference:

Approvals: Process Plan: UMF Date: 11-02-28 Tooling:

Date:

QC: Date: SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3536	Rev A

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

I-Cut as per Dwg D3536 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Deburr if necessary

11-2-28

(26)

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

11-2-28

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

11-02-28

count
(+26)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66559

Tuesday, February 22, 2011 9:56:34 AM

Page 2

Item ID: D3536-15

Accept

Setup Start

Revision ID:

Stop

Item Name: Gasket

Start Date: 2/23/2011 Start Qty: 20.00

Cust Item ID:

Required Date: 3/4/2011 Req'd Qty: 20.00

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: *6P*

0.00



Packaging

Memo

0.00

Packaging

11/2/08 sf 260

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/03/01 HJ
C211/03/01

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Picklist Print

Tuesday, February 22, 2011 9:56:32 AM

Page 1

Work Order ID: 66559

Parent Item: D3536-15

Parent Item Name: Gasket



Start Date: 2/23/2011

Required Date: 3/4/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	465.0000	0.9848	21.88444	26,		
NEOPRENE SHEET 0.063													

Location

Loc Qty

Loc Code

MAT

465

115916

65

116832

400

116832

26

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 66559
Description: Gasket		Part Number: D3536-15
Inspection Dwg: D3536	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
39.15	+/-0.030	39.15			T HB01	
35.65	+/-0.030	35.65			T	
33.65	+/-0.030	33.65			T	
30.15	+/-0.030	30.15			T	
24.90	+/-0.030	24.90			T	
19.65	+/-0.030	19.65			T	
14.40	+/-0.030	14.40			T	
9.15	+/-0.030	9.15			T	
5.65	+/-0.030	5.65			T	
3.90	+/-0.030	3.90			T	
8.00	+/-0.030	8.00			T	
16.00	+/-0.030	16.00			T	
24.00	+/-0.030	24.00			T	
0.30	+/-0.030	0.30			V HB02	
0.30	+/-0.030	0.30			V	
1.89	+/-0.030	1.890			V	
Ø0.19	+0.005/-0.001	0.191			V	

Measured by: IB	Audited by: S	Prototype Approval:	N/A
Date: 11-2-28	Date: 11/02/28	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	

W/O:		WORK ORDER CHANGES					
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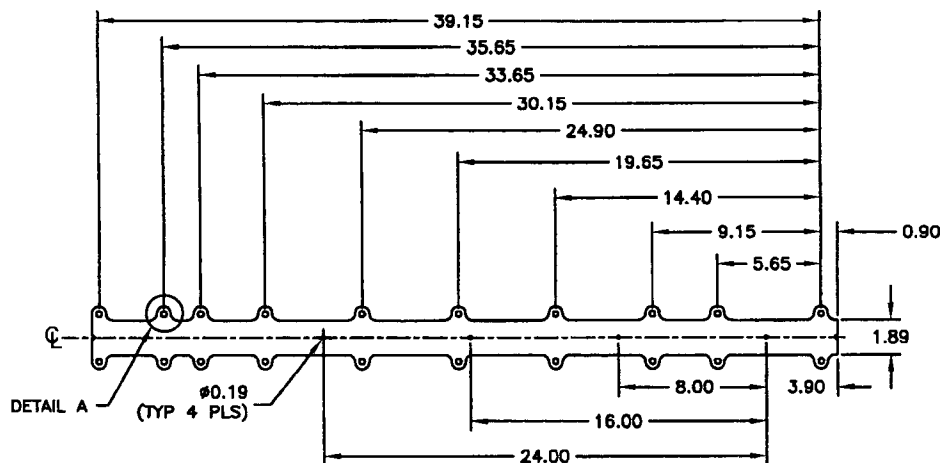
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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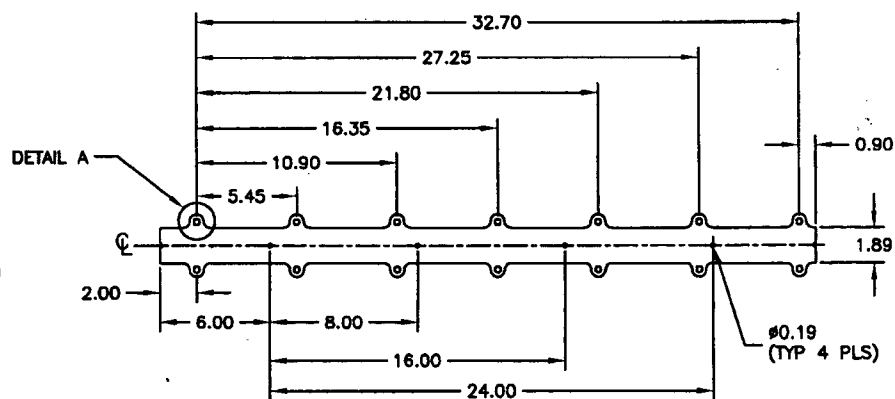
NOTE: Date & initial all entries

DART

DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	PH	APPROVED	PH	
DATE	06.10.25	DRAWING NO.	D3536	
		TITLE	GASKET	
SCALE	1:10	SHEET 2 OF 6		

RELEASED
070212**D3536-15 GASKET**

#66559

**D3536-21 GASKET****NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

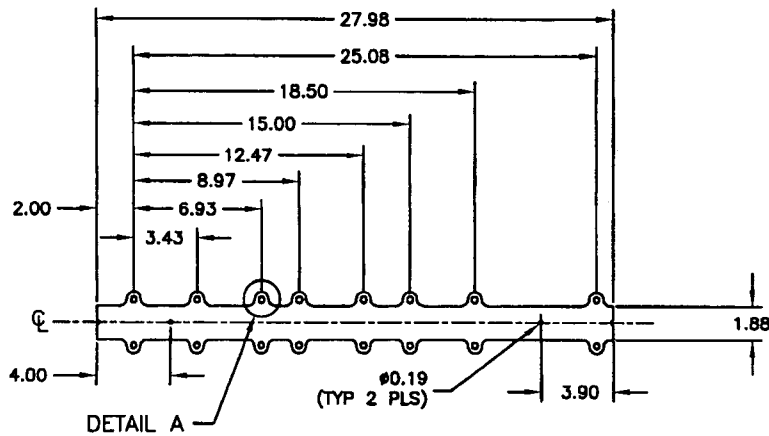
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED PH	DRAWING NO. D3536	REV. A
DATE 06.10.25	TITLE GASKET	SHEET 6 OF 6	SCALE 1:10

07.02.12 **CH**



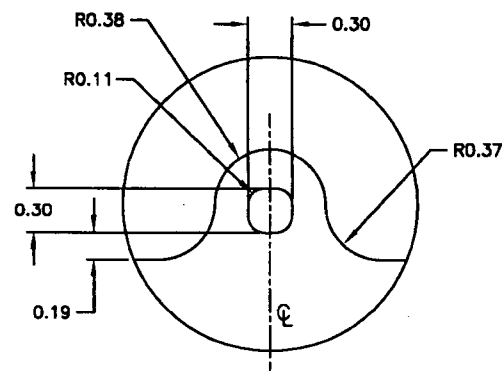
D3536-41 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

#66557

DETAIL A



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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